

Work Order ID 143590

Wednesday, March 16, 2016 2:01:40 PM

143590

Page 1

Item ID: D4857-M

Accept

DAS
13
9-89***N900040100***Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wiper Deflector

Start Date: 3/16/2016 Start Qty: 10.00

10

JUN 29 2016

Cust Item ID:

Required Date: 4/15/2016 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: 

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4857

F

100

0.00

100

Purchasing

Memo

31722

0.00

Purchasing

Issue P/O:

Possible supplier: CARBON BY DESIGN

Manufacture as per dwg D4857-M

Prime Deflector as per dwg (SEE NOTE 4)

Certificate of Conformity release note is required.

 16-0316 11

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

 SP/6-10-26

Work Order ID 143590

Wednesday, March 16, 2016 2:01:40 PM

143590

Page 2

Item ID: D4857-M**Accept*****N900040100*****Setup****Start*****NS1*****Revision ID:****Stop*****NS2*****Item Name:** Wiper Deflector**Start Date:** 3/16/2016 **Start Qty:** 10.00***10*****Cust Item ID:****Required Date:** 4/15/2016 **Req'd Qty:** 10.00***10*****Customer:****Reference:****Approvals:****Process Plan:** _____**Date:** _____**Tooling:** _____**Date:** _____**Run****Start*****NR1*****QC:** _____**Date:** _____**SPC (Y/N):** _____**Date:** _____**Stop*****NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

Pto →
NCL16-6173

130

Identify as per dwg & Stock Location: _____

0.00

130

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.02

Quality Control

w 16.11.15



Supplier Non-Conformance Report

Reviewed
DQA:
Date:

Printed on: Tuesday, November 15, 2016

Details			
Raised Date 11/15/2016	Status Open	Owner Maranda, Denis	Number NCR16-6123
Target Date 11/25/2016	Standard		Severity MINOR
Process Inspection		Audit	
Raised By Person Downing, Eric M	Raised Against (Department or Supplier) FDC Composites Inc.		Fault Category Supplier
Details D4857-M purchased from FDC for FAI inspection had the holes drilled. not per request on PO.			
Keywords		Product D4857-M	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Corrective Action			
Target Date 11/25/2016	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
1	Downing, Eric M	11/18/2016	
contact supplier			
2	Downing, Eric M	11/18/2016	
scrap part		Scrap 1/25 Part scrap	

Verification & Review

Target Date 11/25/2016	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions

Number	Owner	Target Date	Completed Date
Details		Response	

Picklist Print

Wednesday, March 16, 2016 2:01:39 PM

Page 1

Work Order ID: 143590

143590

Parent Item: D4857-M

D4857-M

Parent Item Name: Wiper Deflector

Start Date: 3/16/2016

Required Date: 4/15/2016

Start Qty: 10.00

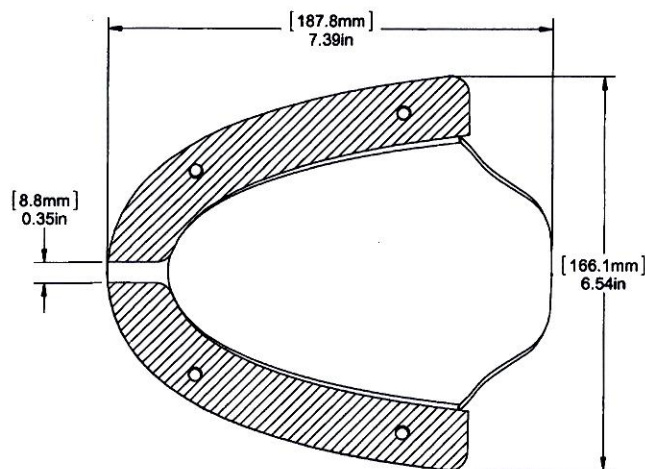
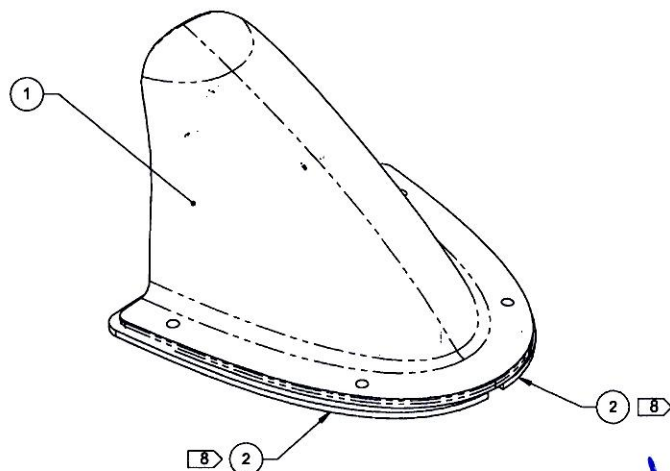
Required Qty: 10.00

Comments: IPP REV:A 14.05.21 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4857-P		Purchased	No				Each	5.0000		10			
D4857-P									**				
Wiper Deflector													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				ST			5						
				m140559			5						

1x 14 SP16-10-26

ITEM	QTY	P/N	DESCRIPTION
	X	D4857-041	WIPER DEFLECTOR ASSY
1	1	D4857-1	WIPER DEFLECTOR
2	2	D4944-1	GASKET



D4857-041 WIPER DEFLECTOR ASSY ⚠

RELEASED

2015 JUN 08

EC N 15-582 *W*

WLB 143590

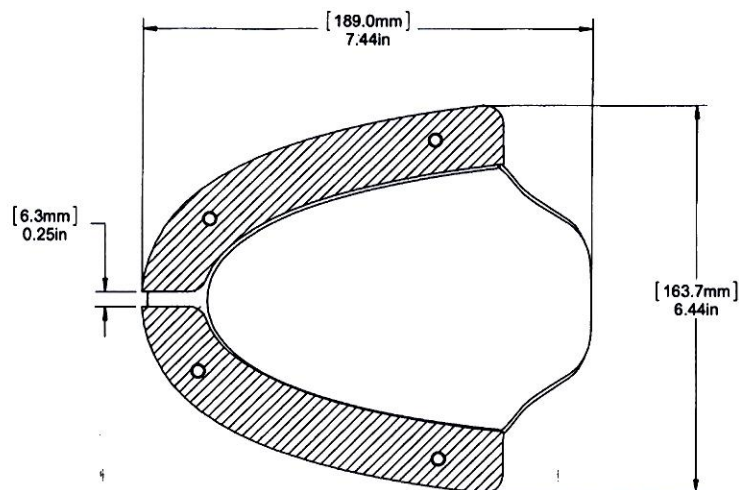
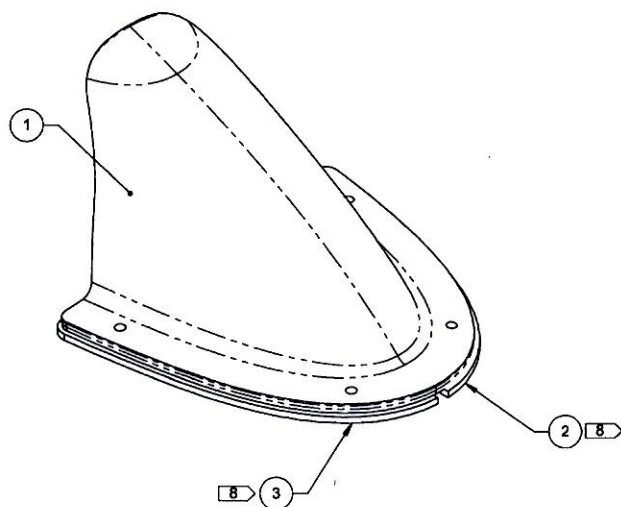
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D4857-041, REVISION, BATCH NUMBER, AND DATE OF MANUFACTURE, AS PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.38 lbs (0.17 kg)
- 8) BOND D4944-1 GASKETS TO EDGE OF PART USING DOW CORNING 736 ADHESIVE

F	SHT 1 ADDED -041. ADDED D4857-2M (SHEET 8) AND RELABELED D4857-M TO D4857-1M (ZN B5-7). UPDATED D4757-044 (ZN B5-3). REVISED NOTES 1, 8 AND 10 (ZN A8-4, ZN A8-5, ZN A8-6, ZN A8-7, ZN A8-8). UPDATE PART WEIGHTS	AK / AJS	15.06.03
E	REVISE NOTE 8) (ZN A8-1, A8-2, A8-3); AND NOTE 8) (ZN A8-1, A8-2, A8-3)	AK	14.06.05
D	ADDED D4857-043 (ZN C7-1), D4857-044 (ZN C7-2), D4857-3 (ZN C7-4), D4857-4 (ZN C7-5) AND D4857-M (ZN C7-6)	AK	14.05.13
C	ADDED 4 MOUNTING HOLES	DW	13.12.09
B	REVISED BOM, DRAWING VIEWS, NOTES	PB	13.08.13
A	NEW RELEASE	DB	13.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	CP	DRAWING NO.	REV. F
MFG. APPR.	DD	D4857	SHEET 1 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WIPER DEFLECTOR	NTS
DATE	15.06.03	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4857-043	WIPER DEFLECTOR ASSEMBLY, LH
1	1	D4857-3	WIPER DEFLECTOR LH
2	1	D5117-1	GASKET
3	1	D5117-3	GASKET



D4857-043 WIPER DEFLECTOR ASSEMBLY, LH

RELEASED

2015 JUN 08

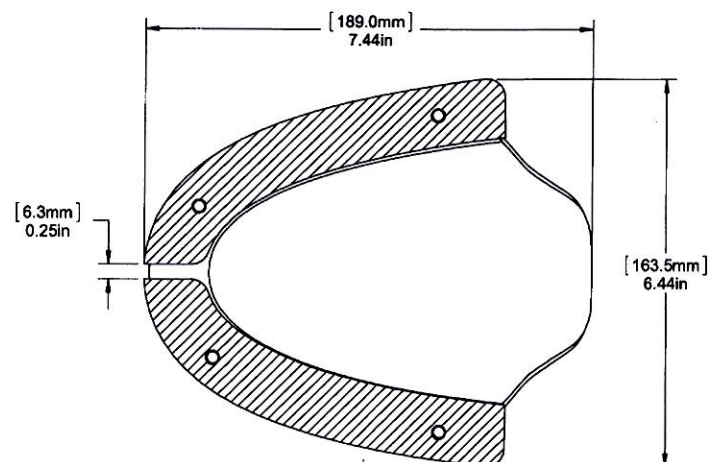
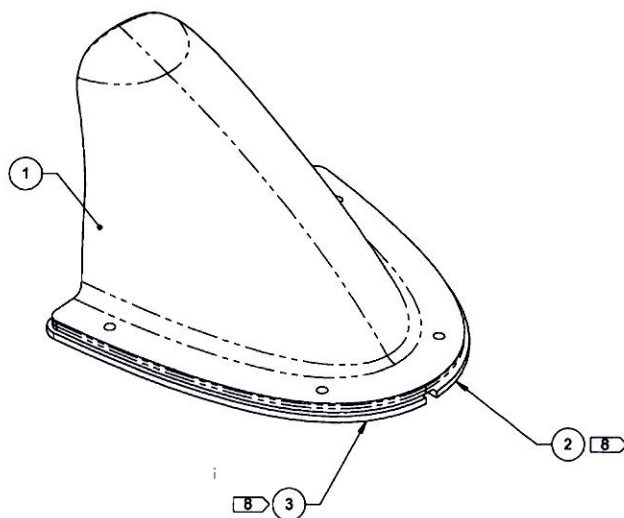
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D4857-043, REVISION, BATCH NUMBER, AND DATE OF MANUFACTURE, AS PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.38 lbs (0.17 kg)
- 8) BOND D5117-1/-3 GASKETS TO EDGE OF PART USING DOW CORNING 736 ADHESIVE

APPROVED

DESIGN		DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	CP	DRAWING NO.	REV. F
MFG. APPR.	DD	D4857	SHEET 2 OF 8
APPROVED	WM	TITLE	SCALE
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ITEM	QTY -044	P/N	DESCRIPTION
	X	D4857-044	WIPER DEFLECTOR ASSEMBLY, RH
1	1	D4857-4	WIPER DEFLECTOR
2	1	D5117-5	GASKET
3	1	D5117-7	GASKET



D4857-044 WIPER DEFLECTOR ASSEMBLY, RH

RELEASED

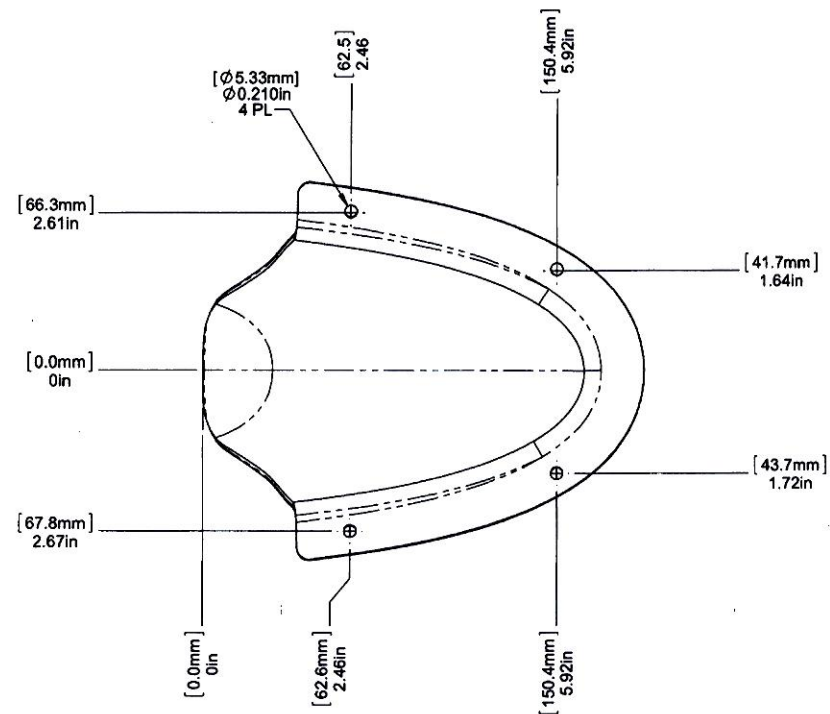
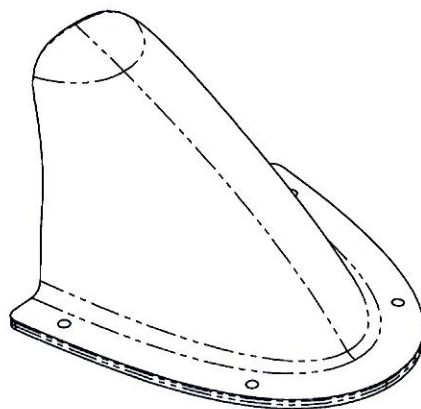
2015 JUN 08

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D4857-044, REVISION, BATCH NUMBER, AND DATE OF MANUFACTURE, AS PER QSI 044 METHOD 6.1
- 7) WEIGHT: 0.38 lbs (0.17 kg)
- 8) BOND D5117-5/-7 GASKETS TO EDGE OF PART USING DOW CORNING 736 ADHESIVE

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DRAWN	AJS		
CHECKED	CP	DRAWING NO.	REV. F
MFG. APPR.	DD	D4857	SHEET 3 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WIPER DEFLECTOR	NTS
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D4857-1 WIPER DEFLECTOR

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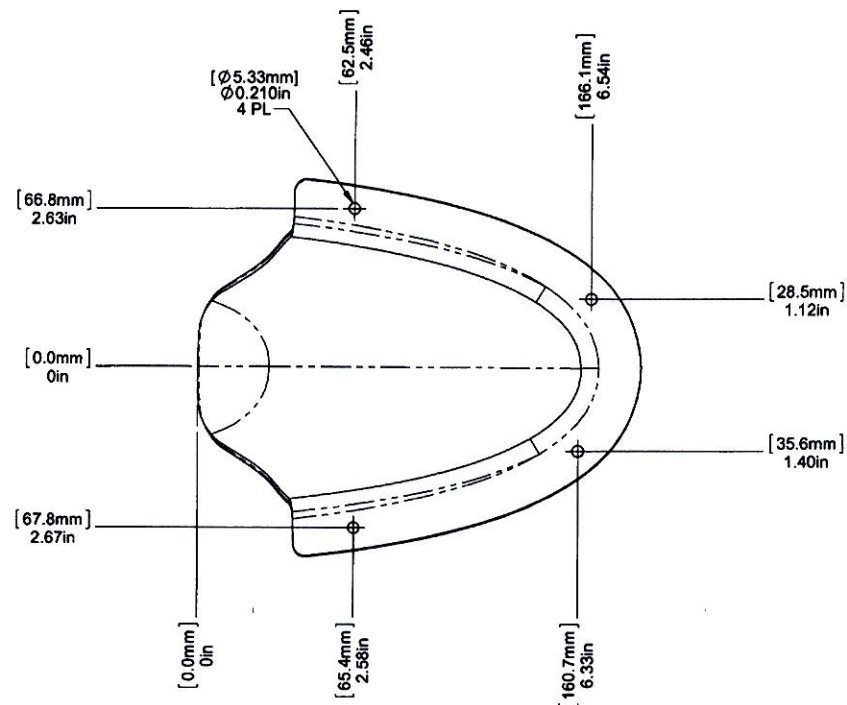
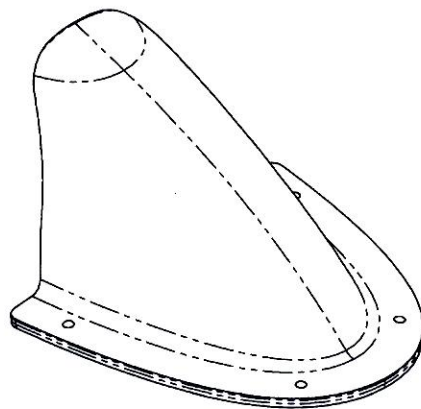
2015 JUN 08

NOTES:

- 1) MATERIAL: MADE FROM D4857-M
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.35 lbs (0.16 kg)
- 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE D4857-1-F.IGES

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DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	CP	DRAWING NO.	REV. F
MFG. APPR.	DD	D4857	SHEET 4 OF 8
APPROVED	WM	TITLE	SCALE
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D4857-3 WIPER DEFLECTOR, LH

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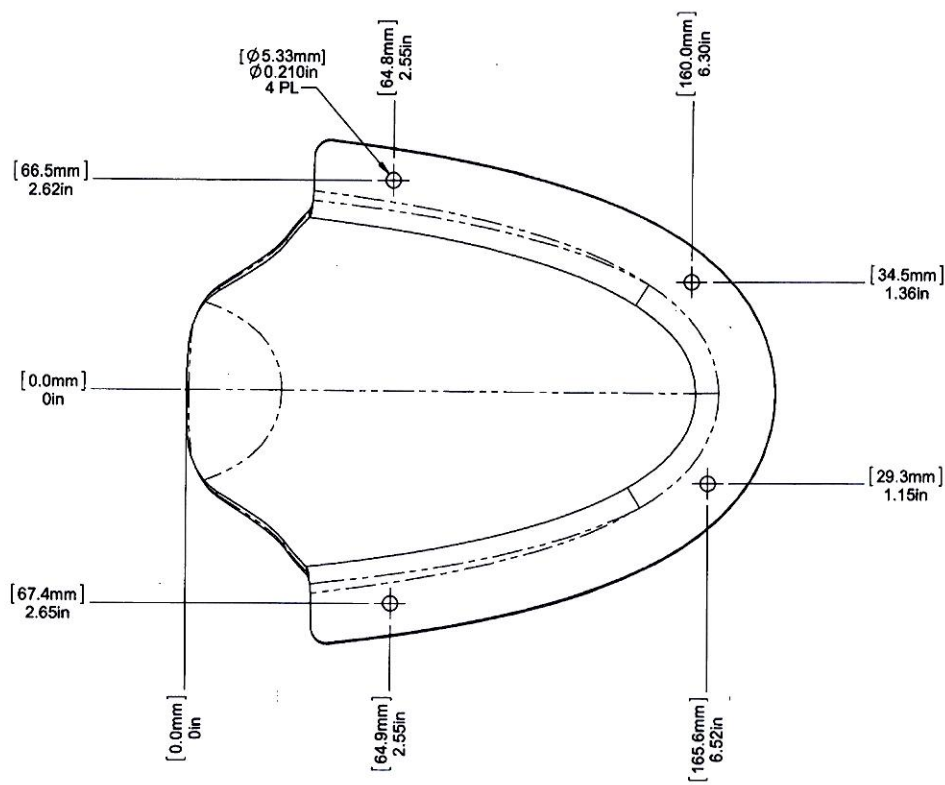
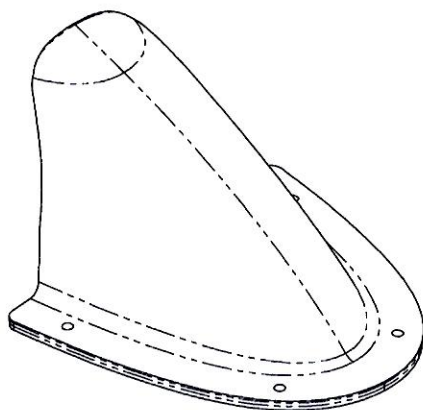
NOTES:

- 1) MATERIAL: MADE FROM D4857-M
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.35 lbs (0.16 kg)
- 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE D4857-3-F.IGES



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DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	CP	DRAWING NO. D4857	REV. F SHEET 5 OF 8
MFG. APPR.	DD	TITLE WIPER DEFLECTOR	SCALE NTS
APPROVED	WM	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.	DS		
DATE	15.06.03		



D4857-4 WIPER DEFLECTOR, RH

RELEASED

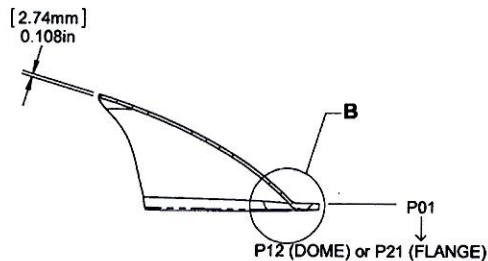
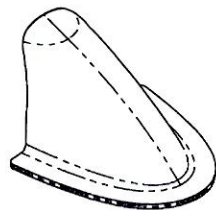
2015 JUN 08

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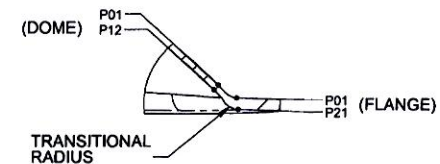
- 1) MATERIAL: MADE FROM D4857-M
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.35 lbs (0.16 kg)
- 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE D4857-4-F.IGES

APPROVED

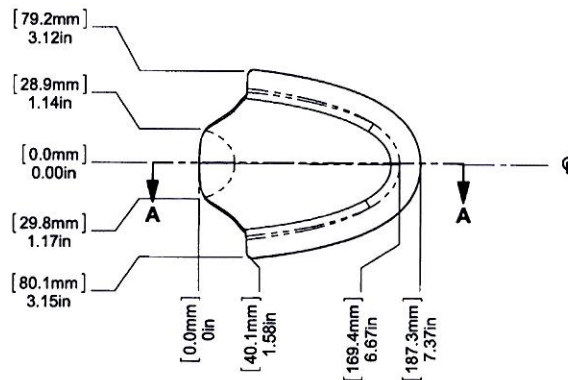
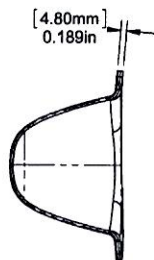
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DRAWN	AJS		
CHECKED	CP	DRAWING NO.	REV. F
MFG. APPR.	DD	D4857	SHEET 6 OF 8
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	WIPER DEFLECTOR	NTS
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SECTION A-A



DETAIL B



D4857-M WIPER DEFLECTOR

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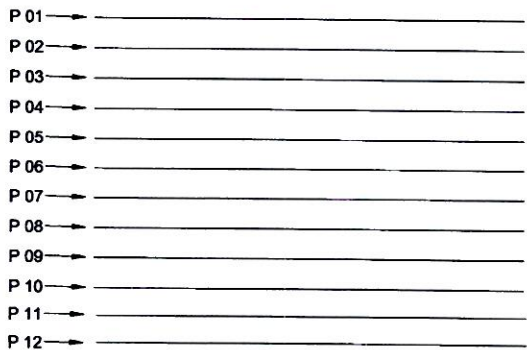
2015 JUN 08

NOTES:

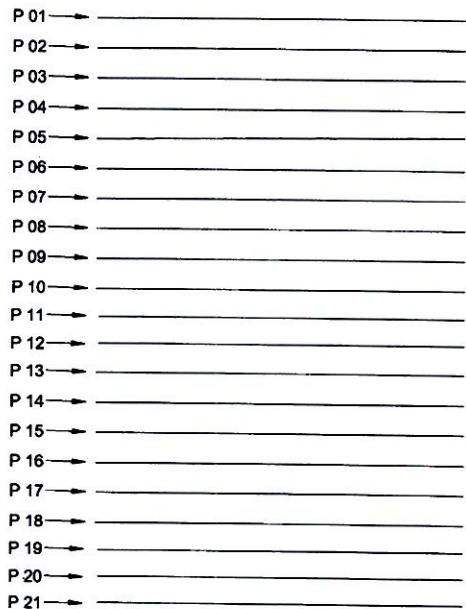
- 1) MATERIAL: KEVLAR #285/353 4H SATIN, EPOXY PREPREG, 250°F CURE, 40% R/C
- 2) MATERIAL: CARBON FIBER PREPREG, ALDILA PREPREG SYSTEM 3K2X2-FR250-204/40 T300,
- 3) MATERIAL: ALDILA #120 E-GLASS AR250 WITH 48% RC;
- 4) FINISH: PRIMER IAW MIL-P-85582, 2-7 MIL MAX.
- 5) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) UNITS: INCHES UNLESS OTHERWISE NOTED, ALL METRIC DIMENSIONS ARE REFERENCE DIMENSIONS.
- 7) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 8) IDENTIFICATION: N/A
- 9) WEIGHT: 0.35 lbs (0.16 kg)
- 10) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE D4857-M-F.IGES
- 11) SEE SHEET 8 FOR LAYUP SCHEDULE. MANUFACTURE IAW MPP 145. CURE 250°F FOR 4 HOURS.

APPROVED

DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	CP	DRAWING NO.	REV. F
MFG. APPR.	DD	D4857	SHEET 7 OF 8
APPROVED	WM	TITLE	SCALE
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LAYUP OF LAYERS (DOME)		
LAMINATE - .108in (12 LAYERS)		
PLY	WARP ANGLE	THICKNESS
01	90	.008-.010
02	0	.008-.010
03	90	.008-.010
04	0	.008-.010
05	90	.008-.010
06	0	.008-.010
07	90	.008-.010
08	0	.008-.010
09	90	.008-.010
10	0	.008-.010
11	90	.008-.010
12	0	.008-.010



LAYUP OF LAYERS (FLANGE)		
LAMINATE - .189in (21 LAYERS)		
PLY	WARP ANGLE	THICKNESS
01	90	.008-.010
02	0	.008-.010
03	90	.008-.010
04	0	.008-.010
05	90	.008-.010
06	0	.008-.010
07	90	.008-.010
08	0	.008-.010
09	90	.008-.010
10	0	.008-.010
11	90	.008-.010
12	0	.008-.010
13	90	.008-.010
14	0	.008-.010
15	90	.008-.010
16	0	.008-.010
17	90	.008-.010
18	0	.008-.010
19	90	.008-.010
20	0	.008-.010
21	90	.008-.010

APPROVED

DESIGN	DW	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	CP	REV. F
MFG. APPR.	DD	D4857
APPROVED	WM	SHEET 8 OF 8
DATE	15.06.03	SCALE
		NTS

RELEASED
2015 JUN 08

WIPER DEFLECTOR

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO31722**

Purchase Order Date 3/16/2016

PO Print Date 6/29/2016

Page Number 1 of 2

Order From : VU-FDC001

FDC COMPOSITES INC.
45 CHEMIN DE L'AEROPORT
LOCAL 26
ST. JEAN SUR RICHELIEU, QUEBEC J3B 7B5

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

Contact Name
Vendor Phone 450-357-1344 Ext 303

Ship To Contact

Ship To Phone

Ship Via: To Be Announced

Ship Acct:

Buyer Linda Lacelle
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency USD
FOB Destination-Collect

JUN 29 2016

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	D4857-P	Wiper Deflector	8/30/2016 Yes 8/30/2016	FN	11.00 Each	\$775.00	\$8,525.00
	MANUFACTURE PER DRWG D4857-M REV.F PRIME DEFLECTOR PER DRWG(SEE NOTE 4) B143590						
						Line Total:	\$8,525.00
2	D4857-P	Wiper Deflector	10/20/2016 Yes 10/20/2016	FN	11.00 Each	\$775.00	\$8,525.00
	MANUFACTURE PER DRWG D4857-M REV.F PRIME DEFLECTOR PER DRWG(SEE NOTE 4) B143591						
						Line Total:	\$8,525.00

PO Instructions: QUOTE NO. 1294

Note:

6/29/2016

FDC Composites inc.
45, Chemin de L'Aéroport
Local 26
Saint-Jean-sur-Richelieu (QC)
J3B 7B5
Tel. : 450 357-1344

Shipping Order 21/10/2016

Order : 5764 Rev A
Reference : PO #31722/1
Ship : FOB USINE FDC PLANT

Customer: DART US

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON
K6A 1K7

Ship To
Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON
K6A 1K7
Tel. : 1 613 632-9577

<i>Item No.</i>	<i>Description</i>	<i>Qty</i>	<i>Qty. Delivered</i>	<i>B/O Qty</i>
D4857-P	Wiper Deflector ✓ PO item: 31722/1 ✓ Lot: 2016-10-18 FDC ID: DAE012-001 As per DRWG: D4857-M Rev. F B143590 50% of 8 525.00\$ Net 30 days	11	1 ✓	10

80/10-26

Shipping : _____
Package No : _____
Merchandise Received: _____
Ref. : _____

CERTIFICATE of CONFORMITY

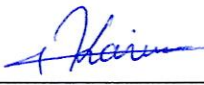
Customer Name: Dart Aerospace.

Customer P/O Number: 31722

Revision: NC

<u>PO Item</u>	<u>Qty</u>	<u>Part number ID</u>	<u>Description</u>	<u>Dwg number ID</u>	<u>Delivery Number</u>	<u>FDC ID</u>	<u>Lot</u>
1	1 (1 sur 11)	D4857-P	Wiper Deflector	D4857-M Rev F	B143590	DAE012-001	2016-10-18

I hereby certify that the workmanship, material and the processes used in the manufacture of the above part(s) supplied are in accordance with the requirements of the applicable Purchase Order.

Signature: 
Karim Malihy, B Eng, Quality Manager

Date: 21 OCT 2016

Operator:	Admin	Date:	7:43 4.11.2016
Part Number:		Work Order:	
Description:		Inspection Dwg:	
Rev:		Measured by:	

Sheet thick.	0.0000 inch	Probe Diam.	0.1569
Meas. mode surface		Meas. mode border	
Max. deviation	0.0808 inch (88)	Max. deviation	inch ()
Mean deviation	0.0145	Mean deviation	
Min. deviation	-0.0761 inch (42)	Min. deviation	inch ()
Best fit			
Shift	inch	inch	inch
Rot.	°	°	°

No.	Meas. X	Meas. Y	Meas. Z	Probe Diam.	
Mode	Cad. X	Cad. Y	Cad. Z	UT	LT
Label	Dev. X	Dev. Y	Dev. Z	Dev.	Dev. String
1	-3.8803	1.9242	3.2734	0.1569	
SurF	-3.8591	1.9325	3.2484	0.0300	-0.0300
	-0.0211	-0.0083	0.0250	0.0338	---+--->>
2	-4.1780	1.6522	2.8301	0.1569	
SurF	-4.1559	1.6581	2.8149	0.0300	-0.0300
	-0.0221	-0.0059	0.0152	0.0274	---+*****
3	-4.3845	1.3863	2.3304	0.1569	
SurF	-4.3710	1.3892	2.3239	0.0300	-0.0300
	-0.0135	-0.0029	0.0065	0.0153	---+***--
4	-4.5554	1.1120	1.7695	0.1569	
SurF	-4.5510	1.1128	1.7678	0.0300	-0.0300
	-0.0044	-0.0008	0.0016	0.0048	---+*---
5	-4.7110	0.8340	1.1461	0.1569	
SurF	-4.7149	0.8334	1.1473	0.0300	-0.0300
	0.0039	0.0006	-0.0012	-0.0042	---*+---

Operator		Admin		Date	
				7:43 4.11.2016	
No.	Meas. X	Meas. Y	Meas. Z	Probe Diam.	
Mode	Cad. X	Cad. Y	Cad. Z	UT	LT
Label	Dev. X	Dev. Y	Dev. Z	Dev.	Dev. String
6	-4.8634	0.5626	0.4675	0.1569	
SurF	-4.8713	0.5615	0.4696	0.0300	-0.0300
	0.0079	0.0011	-0.0021	-0.0083	---*+---
7	-4.7071	-0.4154	0.4678	0.1569	
SurF	-4.7172	-0.4173	0.4710	0.0300	-0.0300
	0.0101	0.0019	-0.0032	-0.0108	---**+---
8	-4.5570	-0.0413	1.1477	0.1569	
SurF	-4.5611	-0.0421	1.1493	0.0300	-0.0300
	0.0042	0.0008	-0.0015	-0.0045	---*+---
9	-4.4056	0.3589	1.7743	0.1569	
SurF	-4.3974	0.3608	1.7706	0.0300	-0.0300
	-0.0082	-0.0019	0.0037	0.0092	-----+**--
10	-4.2334	0.7727	2.3372	0.1569	
SurF	-4.2183	0.7770	2.3283	0.0300	-0.0300
	-0.0151	-0.0043	0.0089	0.0180	-----+***--
11	-4.0229	1.1919	2.8366	0.1569	
SurF	-4.0053	1.1985	2.8213	0.0300	-0.0300
	-0.0177	-0.0066	0.0154	0.0243	-----+****-
12	-3.7308	1.6315	3.2751	0.1569	
SurF	-3.7159	1.6399	3.2524	0.0300	-0.0300
	-0.0149	-0.0084	0.0227	0.0284	-----+*****
13	-3.5452	1.3762	3.2798	0.1569	
SurF	-3.5344	1.3852	3.2566	0.0300	-0.0300
	-0.0108	-0.0090	0.0232	0.0271	-----+*****
14	-3.8174	0.7567	2.8454	0.1569	
SurF	-3.8033	0.7643	2.8284	0.0300	-0.0300
	-0.0141	-0.0076	0.0170	0.0234	-----+****-

Operator		Admin		Date	
				7:43 4.11.2016	
No.	Meas. X	Meas. Y	Meas. Z	Probe Diam.	
Mode	Cad. X	Cad. Y	Cad. Z	UT	LT
Label	Dev. X	Dev. Y	Dev. Z	Dev.	Dev. String
15	-4.0244	0.1651	2.3452	0.1569	
SurF	-4.0099	0.1710	2.3336	0.0300	-0.0300
	-0.0145	-0.0058	0.0116	0.0195	----+***--
16	-4.1965	-0.4017	1.7808	0.1569	
SurF	-4.1857	-0.3982	1.7744	0.0300	-0.0300
	-0.0108	-0.0035	0.0064	0.0131	----+**--
17	-4.3445	-0.9331	1.1525	0.1569	
SurF	-4.3454	-0.9334	1.1530	0.0300	-0.0300
	0.0010	0.0003	-0.0005	-0.0011	----+----
18	-4.4892	-1.4154	0.4705	0.1569	
SurF	-4.4964	-1.4173	0.4733	0.0300	-0.0300
	0.0072	0.0019	-0.0028	-0.0080	----*+----
19	-4.1621	-2.4080	0.4757	0.1569	
SurF	-4.1667	-2.4099	0.4781	0.0300	-0.0300
	0.0046	0.0019	-0.0024	-0.0055	----*+----
20	-4.0341	-1.8109	1.1616	0.1569	
SurF	-4.0306	-1.8093	1.1592	0.0300	-0.0300
	-0.0035	-0.0016	0.0023	0.0045	----+*----
21	-3.8941	-1.1371	1.7902	0.1569	
SurF	-3.8834	-1.1316	1.7808	0.0300	-0.0300
	-0.0107	-0.0055	0.0094	0.0152	----+***--
22	-3.7339	-0.4045	2.3554	0.1569	
SurF	-3.7213	-0.3966	2.3401	0.0300	-0.0300
	-0.0126	-0.0078	0.0153	0.0213	----+****-
23	-3.5475	0.3706	2.8539	0.1569	
SurF	-3.5374	0.3791	2.8350	0.0300	-0.0300
	-0.0101	-0.0084	0.0189	0.0230	----+****-

Operator		Admin		Date	
				7:43 4.11.2016	
No.	Meas. X	Meas. Y	Meas. Z	Probe Diam.	
Mode	Cad. X	Cad. Y	Cad. Z	UT	LT
Label	Dev. X	Dev. Y	Dev. Z	Dev.	Dev. String
24	-3.3209	1.1721	3.2846	0.1569	
SurF	-3.3137	1.1817	3.2600	0.0300	-0.0300
	-0.0072	-0.0095	0.0246	0.0273	-----+*****
25	-3.0588	1.0312	3.2871	0.1569	
SurF	-3.0551	1.0407	3.2621	0.0300	-0.0300
	-0.0038	-0.0095	0.0250	0.0270	-----+*****
26	-3.2048	0.0699	2.8592	0.1569	
SurF	-3.1989	0.0789	2.8387	0.0300	-0.0300
	-0.0059	-0.0090	0.0205	0.0231	-----+*****
27	-3.3344	-0.8706	2.3627	0.1569	
SurF	-3.3269	-0.8618	2.3457	0.0300	-0.0300
	-0.0075	-0.0087	0.0170	0.0205	-----+***-
28	-3.4558	-1.7532	1.8010	0.1569	
SurF	-3.4482	-1.7456	1.7887	0.0300	-0.0300
	-0.0075	-0.0075	0.0124	0.0163	-----+***-
29	-3.5654	-2.5597	1.1746	0.1569	
SurF	-3.5602	-2.5551	1.1682	0.0300	-0.0300
	-0.0052	-0.0047	0.0063	0.0094	-----+**-
30	-3.6585	-3.2736	0.4859	0.1569	
SurF	-3.6592	-3.2742	0.4865	0.0300	-0.0300
	0.0007	0.0006	-0.0006	-0.0011	-----+-----
31	-2.9159	-3.7563	0.4959	0.1569	
SurF	-2.9159	-3.7564	0.4961	0.0300	-0.0300
	0.0000	0.0001	-0.0001	-0.0002	-----+-----
32	-2.8936	-2.9711	1.1860	0.1569	
SurF	-2.8919	-2.9636	1.1762	0.0300	-0.0300
	-0.0017	-0.0075	0.0098	0.0124	-----+**-

Operator		Admin		Date	
				7:43 4.11.2016	
No.	Meas. X	Meas. Y	Meas. Z	Probe Diam.	
Mode	Cad. X	Cad. Y	Cad. Z	UT	LT
Label	Dev. X	Dev. Y	Dev. Z	Dev.	Dev. String
33	-2.8658	-2.0803	1.8119	0.1569	
SurF	-2.8637	-2.0700	1.7954	0.0300	-0.0300
	-0.0021	-0.0103	0.0165	0.0195	---+***--
34	-2.8347	-1.1086	2.3663	0.1569	
SurF	-2.8331	-1.0996	2.3490	0.0300	-0.0300
	-0.0016	-0.0089	0.0173	0.0195	---+***--
35	-2.8031	-0.0834	2.8571	0.1569	
SurF	-2.8019	-0.0751	2.8381	0.0300	-0.0300
	-0.0012	-0.0083	0.0190	0.0208	---+***--
36	-2.7689	0.9641	3.2864	0.1569	
SurF	-2.7680	0.9730	3.2624	0.0300	-0.0300
	-0.0008	-0.0089	0.0239	0.0256	---+****-
37	-1.4766	1.9332	3.2462	0.1569	
SurF	-1.4642	1.9281	3.2614	0.0300	-0.0300
	-0.0124	0.0050	-0.0152	-0.0203	---***+---
38	-1.1930	1.6609	2.8092	0.1569	
SurF	-1.1614	1.6523	2.8315	0.0300	-0.0300
	-0.0316	0.0086	-0.0223	-0.0396	<<---+---
39	-0.9883	1.3906	2.3188	0.1569	
SurF	-0.9417	1.3807	2.3416	0.0300	-0.0300
	-0.0466	0.0099	-0.0227	-0.0528	<<---+---
40	-0.8177	1.1151	1.7672	0.1569	
SurF	-0.7597	1.1049	1.7890	0.0300	-0.0300
	-0.0580	0.0102	-0.0219	-0.0628	<<---+---
41	-0.6642	0.8377	1.1477	0.1569	
SurF	-0.5940	0.8270	1.1696	0.0300	-0.0300
	-0.0701	0.0106	-0.0218	-0.0742	<<---+---

Operator		Admin		Date	
				7:44 4.11.2016	
No.	Meas. X	Meas. Y	Meas. Z	Probe Diam.	
Mode	Cad. X	Cad. Y	Cad. Z	UT	LT
Label	Dev. X	Dev. Y	Dev. Z	Dev.	Dev. String
42	-0.5087	0.5667	0.4713	0.1569	
SurF	-0.4358	0.5570	0.4912	0.0300	-0.0300
	-0.0728	0.0098	-0.0199	-0.0761	<<--+---
43	-0.6462	-0.4120	0.4729	0.1569	
SurF	-0.5898	-0.4224	0.4908	0.0300	-0.0300
	-0.0564	0.0104	-0.0179	-0.0601	<<--+---
44	-0.8039	-0.0400	1.1495	0.1569	
SurF	-0.7486	-0.0512	1.1699	0.0300	-0.0300
	-0.0553	0.0113	-0.0203	-0.0600	<<--+---
45	-0.9554	0.3587	1.7713	0.1569	
SurF	-0.9144	0.3490	1.7901	0.0300	-0.0300
	-0.0410	0.0097	-0.0188	-0.0461	<<--+---
46	-1.1273	0.7732	2.3258	0.1569	
SurF	-1.0963	0.7642	2.3446	0.0300	-0.0300
	-0.0310	0.0090	-0.0188	-0.0374	<<--+---
47	-1.3341	1.1980	2.8188	0.1569	
SurF	-1.3148	1.1906	2.8362	0.0300	-0.0300
	-0.0193	0.0074	-0.0174	-0.0270	*****+---
48	-1.6157	1.6376	3.2565	0.1569	
SurF	-1.6110	1.6348	3.2639	0.0300	-0.0300
	-0.0047	0.0027	-0.0074	-0.0092	---**+---
49	-1.7968	1.3804	3.2672	0.1569	
SurF	-1.7974	1.3809	3.2660	0.0300	-0.0300
	0.0005	-0.0005	0.0012	0.0014	---+---
50	-1.5293	0.7605	2.8320	0.1569	
SurF	-1.5219	0.7563	2.8414	0.0300	-0.0300
	-0.0075	0.0042	-0.0094	-0.0127	---**+---

Operator		Admin		Date	
				7:44 4.11.2016	
No.	Meas. X	Meas. Y	Meas. Z	Probe Diam.	
Mode	Cad. X	Cad. Y	Cad. Z	UT	LT
Label	Dev. X	Dev. Y	Dev. Z	Dev.	Dev. String
51	-1.3264	0.1642	2.3334	0.1569	
SurF	-1.3087	0.1569	2.3480	0.0300	-0.0300
	-0.0177	0.0073	-0.0147	-0.0241	-****+----
52	-1.1537	-0.4039	1.7772	0.1569	
SurF	-1.1290	-0.4122	1.7921	0.0300	-0.0300
	-0.0247	0.0083	-0.0149	-0.0300	*****+----
53	-0.9979	-0.9357	1.1564	0.1569	
SurF	-0.9660	-0.9449	1.1713	0.0300	-0.0300
	-0.0319	0.0092	-0.0149	-0.0364	<<--+----
54	-0.8504	-1.4127	0.4757	0.1569	
SurF	-0.8107	-1.4232	0.4911	0.0300	-0.0300
	-0.0398	0.0105	-0.0154	-0.0439	<<--+----
55	-1.1615	-2.4067	0.4808	0.1569	
SurF	-1.1398	-2.4158	0.4921	0.0300	-0.0300
	-0.0217	0.0091	-0.0113	-0.0261	-****+----
56	-1.2956	-1.8147	1.1658	0.1569	
SurF	-1.2828	-1.8206	1.1745	0.0300	-0.0300
	-0.0129	0.0059	-0.0086	-0.0166	-***+----
57	-1.4436	-1.1399	1.7888	0.1569	
SurF	-1.4361	-1.1438	1.7955	0.0300	-0.0300
	-0.0075	0.0039	-0.0068	-0.0108	---**+----
58	-1.6076	-0.4058	2.3468	0.1569	
SurF	-1.6039	-0.4082	2.3516	0.0300	-0.0300
	-0.0038	0.0024	-0.0048	-0.0066	---*+----
59	-1.7937	0.3730	2.8471	0.1569	
SurF	-1.7946	0.3738	2.8453	0.0300	-0.0300
	0.0009	-0.0008	0.0018	0.0022	---+----

Operator		Admin		Date	
				7:44 4.11.2016	
No.	Meas. X	Meas. Y	Meas. Z	Probe Diam.	
Mode	Cad. X	Cad. Y	Cad. Z	UT	LT
Label	Dev. X	Dev. Y	Dev. Z	Dev.	Dev. String
60	-2.0218	1.1754	3.2767	0.1569	
SurF	-2.0244	1.1791	3.2671	0.0300	-0.0300
	0.0026	-0.0037	0.0096	0.0106	----+**--
61	-2.2867	1.0333	3.2839	0.1569	
SurF	-2.2891	1.0400	3.2663	0.0300	-0.0300
	0.0024	-0.0067	0.0176	0.0190	----+***--
62	-2.1366	0.0723	2.8565	0.1569	
SurF	-2.1396	0.0772	2.8452	0.0300	-0.0300
	0.0030	-0.0049	0.0113	0.0126	----+**--
63	-2.0024	-0.8717	2.3599	0.1569	
SurF	-2.0052	-0.8682	2.3530	0.0300	-0.0300
	0.0029	-0.0035	0.0069	0.0083	----+*---
64	-1.8738	-1.7529	1.8029	0.1569	
SurF	-1.8762	-1.7504	1.7987	0.0300	-0.0300
	0.0024	-0.0025	0.0042	0.0055	----+*---
65	-1.7540	-2.5606	1.1803	0.1569	
SurF	-1.7554	-2.5594	1.1786	0.0300	-0.0300
	0.0013	-0.0012	0.0017	0.0025	----+---
66	-1.6526	-3.2724	0.4904	0.1569	
SurF	-1.6471	-3.2771	0.4955	0.0300	-0.0300
	-0.0054	0.0047	-0.0052	-0.0089	----*+----
67	-2.3904	-3.7573	0.4969	0.1569	
SurF	-2.3903	-3.7578	0.4974	0.0300	-0.0300
	-0.0001	0.0005	-0.0005	-0.0007	----+----
68	-2.4241	-2.9675	1.1859	0.1569	
SurF	-2.4251	-2.9626	1.1795	0.0300	-0.0300
	0.0010	-0.0049	0.0064	0.0081	----+*---

Operator		Admin		Date	
				7:44 4.11.2016	
No.	Meas. X	Meas. Y	Meas. Z	Probe Diam.	
Mode	Cad. X	Cad. Y	Cad. Z	UT	LT
Label	Dev. X	Dev. Y	Dev. Z	Dev.	Dev. String
69	-2.4617	-2.0767	1.8135	0.1569	
SurF	-2.4633	-2.0678	1.7991	0.0300	-0.0300
	0.0017	-0.0089	0.0144	0.0170	—+***—
70	-2.5016	-1.1074	2.3648	0.1569	
SurF	-2.5028	-1.1001	2.3507	0.0300	-0.0300
	0.0011	-0.0073	0.0141	0.0159	—+***—
71	-2.5410	-0.0817	2.8579	0.1569	
SurF	-2.5419	-0.0739	2.8400	0.0300	-0.0300
	0.0009	-0.0078	0.0178	0.0195	—+***—
72	-2.5821	0.9647	3.2862	0.1569	
SurF	-2.5826	0.9732	3.2635	0.0300	-0.0300
	0.0005	-0.0085	0.0227	0.0242	—+****—
73	-4.9113	-1.1373	0.2479	0.1569	
SurF	-4.9090	-1.1370	0.2090	0.0300	-0.0300
	-0.0023	-0.0003	0.0388	0.0389	—+—>>
74	-4.9407	-1.5253	0.2469	0.1569	
SurF	-4.9382	-1.5248	0.2039	0.0300	-0.0300
	-0.0025	-0.0004	0.0430	0.0430	—+—>>
75	-4.9704	-1.9133	0.2471	0.1569	
SurF	-4.9675	-1.9128	0.1982	0.0300	-0.0300
	-0.0029	-0.0005	0.0489	0.0489	—+—>>
76	-5.0010	-2.3017	0.2464	0.1569	
SurF	-4.9978	-2.3010	0.1919	0.0300	-0.0300
	-0.0032	-0.0007	0.0545	0.0546	—+—>>
77	-5.0318	-2.6901	0.2397	0.1569	
SurF	-5.0286	-2.6893	0.1849	0.0300	-0.0300
	-0.0032	-0.0008	0.0548	0.0549	—+—>>

Operator		Admin		Date	
				7:44 4.11.2016	
No.	Meas. X	Meas. Y	Meas. Z	Probe Diam.	
Mode	Cad. X	Cad. Y	Cad. Z	UT	LT
Label	Dev. X	Dev. Y	Dev. Z	Dev.	Dev. String
78	-4.4870	-3.8487	0.2084	0.1569	
SurF	-4.4863	-3.8483	0.1919	0.0300	-0.0300
	-0.0007	-0.0003	0.0165	0.0165	---+***--
79	-4.4540	-3.4605	0.2588	0.1569	
SurF	-4.4516	-3.4594	0.2011	0.0300	-0.0300
	-0.0024	-0.0011	0.0577	0.0578	---+--->>
80	-4.4199	-3.0718	0.2596	0.1569	
SurF	-4.4178	-3.0709	0.2096	0.0300	-0.0300
	-0.0021	-0.0009	0.0500	0.0500	---+--->>
81	-4.3864	-2.6832	0.2659	0.1569	
SurF	-4.3844	-2.6824	0.2175	0.0300	-0.0300
	-0.0020	-0.0008	0.0484	0.0484	---+--->>
82	-3.8612	-3.8458	0.2719	0.1569	
SurF	-3.8598	-3.8445	0.2128	0.0300	-0.0300
	-0.0015	-0.0013	0.0591	0.0591	---+--->>
83	-3.8990	-4.2350	0.2687	0.1569	
SurF	-3.8974	-4.2334	0.2027	0.0300	-0.0300
	-0.0016	-0.0016	0.0659	0.0660	---+--->>
84	-3.3245	-4.6232	0.2730	0.1569	
SurF	-3.3239	-4.6212	0.2017	0.0300	-0.0300
	-0.0005	-0.0020	0.0713	0.0713	---+--->>
85	-3.2843	-4.2337	0.2788	0.1569	
SurF	-3.2838	-4.2319	0.2127	0.0300	-0.0300
	-0.0005	-0.0018	0.0661	0.0661	---+--->>
86	-2.6803	-4.2349	0.2788	0.1569	
SurF	-2.6810	-4.2330	0.2118	0.0300	-0.0300
	0.0007	-0.0019	0.0671	0.0671	---+--->>

Operator		Admin		Date	
				7:44 4.11.2016	
No.	Meas. X	Meas. Y	Meas. Z	Probe Diam.	
Mode	Cad. X	Cad. Y	Cad. Z	UT	LT
Label	Dev. X	Dev. Y	Dev. Z	Dev.	Dev. String
87	-2.7228	-4.6247	0.2774	0.1569	
SurF	-2.7237	-4.6223	0.2006	0.0300	-0.0300
	0.0008	-0.0024	0.0768	0.0768	---+--->>
88	-2.1312	-4.6283	0.2695	0.1569	
SurF	-2.1336	-4.6256	0.1888	0.0300	-0.0300
	0.0024	-0.0027	0.0807	0.0808	---+--->>
89	-2.0871	-4.2385	0.2680	0.1569	
SurF	-2.0891	-4.2364	0.2001	0.0300	-0.0300
	0.0020	-0.0021	0.0679	0.0680	---+--->>
90	-1.4594	-3.8550	0.2503	0.1569	
SurF	-1.4624	-3.8531	0.1882	0.0300	-0.0300
	0.0030	-0.0020	0.0621	0.0622	---+--->>
91	-1.5047	-4.2451	0.2546	0.1569	
SurF	-1.5084	-4.2425	0.1776	0.0300	-0.0300
	0.0037	-0.0026	0.0770	0.0771	---+--->>
92	-0.8860	-3.8641	0.2208	0.1569	
SurF	-0.8904	-3.8618	0.1548	0.0300	-0.0300
	0.0045	-0.0023	0.0660	0.0662	---+--->>
93	-0.7937	-3.0855	0.2313	0.1569	
SurF	-0.7976	-3.0838	0.1740	0.0300	-0.0300
	0.0039	-0.0018	0.0573	0.0574	---+--->>
94	-0.7489	-2.6967	0.2336	0.1569	
SurF	-0.7524	-2.6952	0.1826	0.0300	-0.0300
	0.0034	-0.0015	0.0510	0.0512	---+--->>
95	-0.7043	-2.3081	0.2357	0.1569	
SurF	-0.7074	-2.3069	0.1904	0.0300	-0.0300
	0.0030	-0.0012	0.0453	0.0454	---+--->>

Operator		Admin		Date	
				7:44 4.11.2016	
No.	Meas. X	Meas. Y	Meas. Z	Probe Diam.	
Mode	Cad. X	Cad. Y	Cad. Z	UT	LT
Label	Dev. X	Dev. Y	Dev. Z	Dev.	Dev. String
96	-0.6620	-1.9191	0.2400	0.1569	
SurF	-0.6657	-1.9177	0.1978	0.0300	-0.0300
	0.0037	-0.0013	0.0421	0.0423	---+--->>
97	0.0019	-1.1544	0.2156	0.1569	
SurF	-0.0025	-1.1532	0.1656	0.0300	-0.0300
	0.0044	-0.0012	0.0499	0.0501	---+--->>
98	-0.0427	-1.5431	0.2132	0.1569	
SurF	-0.0474	-1.5417	0.1598	0.0300	-0.0300
	0.0047	-0.0014	0.0534	0.0537	---+--->>
99	-0.0877	-1.9314	0.2147	0.1569	
SurF	-0.0931	-1.9297	0.1533	0.0300	-0.0300
	0.0054	-0.0017	0.0614	0.0616	---+--->>
100	-0.1340	-2.3198	0.2053	0.1569	
SurF	-0.1392	-2.3181	0.1462	0.0300	-0.0300
	0.0052	-0.0018	0.0591	0.0594	---+--->>